



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3884-1
Job Sheet 187257



Part No: D3884-1

Job Qty: 10 ea

Part Name: Saddle, Inside LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 1/31/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/31/19	1/31/19	0.00	0.00	Start Up Machining-2		SBL 19/01/07
100	CNC Vertical Machining	10 pcs	1/31/19	1/31/19	0.50	18.18	HAAS1-5		SBL 19/01/07
110	QC	10 pcs	1/31/19	1/31/19	0.00	0.00	QC2 Machining-2		SBL BA 19-01-08
120	QC	10 pcs	1/31/19	1/31/19	0.00	0.00	QC8 Machining-2		WIP 19/01/16
130	HandFinish	10 pcs	1/31/19	1/31/19	0.00	0.57	HandFinish1		DR 19/01/16
140	Powdercoat	10 pcs	1/31/19	1/31/19	0.00	0.42	Powdercoat1		BE 19/01/16
150	QC	10 pcs	1/31/19	1/31/19	0.00	0.00	QC3		38
160	Packaging	10 pcs	1/31/19	1/31/19	0.00	0.00	Packaging3-2	5401	9-89
170	QC21-SA	10 Ea	1/31/19	1/31/19	0.00	0.00	QC21	21	JAN 21 2019

Part Op 100 - Program Batch No. 5142246 1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets 2-Descriptions: Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

110 - Inspect on CMM as per folio CMMA004.

140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***

M138997 START: 2:00 TEMP: 320° FINISH: 2:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-017	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	S102530 S142045

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-017	10	19	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Inboard, LH	2.870Inches + 0.010 - 0.000	2.880 2.870		
2	Saddle, Inboard, LH	1.433Inches + 0.010 - 0.000	1.443 1.433		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		DISPOSITION		DEPARTMENT/PROCESS					
Part No. _____				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Proc./Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____				DART AEROSPACE Container No: S142246 Part: D3884-1 Job No: 187257 Serial No/Batch: S142246 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/07/19					
Description Work Order Deviation				MRB (QSIO42)					
				Completed By					
				Lead hand / Supervisor					
						QC / QA Coordinator			

Root Cause		FAULT CATEGORY			
Operator	☐	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
Manufacturing Process	☐	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
Equip/Tooling	☐	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
Handling/Presservation	☐	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
Material	☐	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Product Improvement	☐	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
Process Improvement	☐	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
Human Factors	☐	Other/Details:			

3	Saddle, Inboard, LH	0.638Inches	+ 0.020 - 0.000	0.658 0.638
4	Saddle, Inboard, LH	3.895Inches	+ 0.010 - 0.000	3.905 3.895
5	Saddle, Inboard, LH	0.257Inches	+ 0.005 - 0.000	0.262 0.257
6	Saddle, Inboard, LH	0.605Inches	+ 0.020 - 0.000	0.625 0.605
7	Saddle, Inboard, LH	1.120Inches	+ 0.010 - 0.000	1.130 1.120
8	Saddle, Inboard, LH	2.245Inches	+ 0.010 - 0.000	2.255 2.245
9	Saddle, Inboard, LH	2.000Inches	+ 0.020 - 0.000	2.020 2.000
10	Saddle, Inboard, LH	0.140Inches	+ 0.035 - 0.000	0.175 0.140
11	Saddle, Inboard, LH	1.265Inches	+ 0.020 - 0.000	1.285 1.265
12	Saddle, Inboard, LH	0.115Inches	+ 0.020 - 0.000	0.135 0.115
13	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
14	Saddle, Inboard, LH	0.110Inches	+ 0.030 - 0.000	0.140 0.110
15	Saddle, Inboard, LH	0.240Inches	+ 0.020 - 0.000	0.260 0.240
16	Saddle, Inboard, LH	2.826Inches	+ 0.060 - 0.000	2.886 2.826
17	Saddle, Inboard, LH	0.178Inches	+ 0.020 - 0.000	0.198 0.178
18	Saddle, Inboard, LH	0.140Inches	+ 0.025 - 0.000	0.165 0.140
19	Saddle, Inboard, LH	0.720Inches	+ 0.060 - 0.000	0.780 0.720
20	Saddle, Inboard, LH	1.220Inches	+ 0.060 - 0.000	1.280 1.220
21	Saddle, Inboard, LH	1.245Inches	+ 0.010 - 0.000	1.255 1.245
22	Saddle, Inboard, LH	5.990Inches	+ 0.020 - 0.000	6.010 5.990
23	Saddle, Inboard, LH	2.495Inches	+ 0.010 - 0.000	2.505 2.495
24	Saddle, Inboard, LH	0.490Inches	+ 0.020 - 0.000	0.510 0.490
25	Saddle, Inboard, LH	0.020Inches	+ 0.020 - 0.000	0.040 0.020
26	Saddle, Inboard, LH	0.313Inches	+ 0.005 - 0.000	0.318 0.313
27	Saddle, Inboard, LH	0.760Inches	+ 0.005 - 0.000	0.765 0.760
28	Saddle, Inboard, LH	0.215Inches	+ 0.005 - 0.000	0.220 0.215
29	Saddle, Inboard, LH	0.316Inches	+ 0.005 - 0.000	0.321 0.316
30	Saddle, Inboard, LH	1.745Inches	+ 0.010 - 0.000	1.755 1.745
31	Saddle, Inboard, LH	0.990Inches	+ 0.020 - 0.000	1.010 0.990

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 187257	
Description: Saddle, Inboard, LH		Part Number: D3884-1	
Inspection Dwg: D3884		Rev. C	
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.644	0.648	0.648	0.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.612	0.616	0.616	0.617		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		0.151	0.153	0.152	0.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		0.125	0.125	0.125	0.125		
M	0.240	0.260		0.250	0.250	0.249	0.249		
N	0.110	0.140		0.135	0.130	0.130	0.130		
O	0.240	0.260		0.247	0.249	0.250	0.251		
P	2.826	2.886		2.856	2.858	2.858	2.858		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.150	0.152	0.150	0.151		
S	0.720	0.780		0.750	0.760	0.760	0.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.496	0.500	0.499	0.500		
Y	0.020	0.040		0.038	0.033	0.033	0.033		
Z	0.313	0.318		0.313	0.313	0.313	0.313		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.220	0.219	0.220	0.215		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		0.998	0.999	1.000	1.000		
AF									
Accept/Reject									

Measured by:	DAS
Date:	57 19/01/07
	9-89

Audited by:	
Date:	19/01/16

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 187257
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.649	0.649	0.649	0.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.617	0.617	0.617	0.617		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		0.152	0.153	0.152	0.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		0.125	0.125	0.125	0.125		
M	0.240	0.260		0.249	0.249	0.249	0.249		
N	0.110	0.140		0.130	0.130	0.130	0.130		
O	0.240	0.260		0.249	0.250	0.250	0.250		
P	2.826	2.886		2.858	2.858	2.858	2.858		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.150	0.150	0.150	0.150		
S	0.720	0.780		0.760	0.760	0.760	0.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.499	0.500	0.500	0.500		
Y	0.020	0.040		0.033	0.033	0.033	0.033		
Z	0.313	0.318		0.313	0.313	0.313	0.313		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by: <i>AF</i>
Date: 19-01-08

Audited by: <i>MP</i>
Date: 19/01/16

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 187257
Description: Saddle, Inboard, LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	3	4		
A	2.870	2.880		2.875	2.875				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		0.649	0.649				
D	3.895	3.905		3.900	3.900				
E	0.257	0.262		0.258	0.258				
F	0.605	0.625		0.617	0.617				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.000	2.000				
J	0.140	0.175		0.151	0.150				
K	1.265	1.285		1.265	1.265				
L	0.115	0.135		0.125	0.125				
M	0.240	0.260		0.249	0.249				
N	0.110	0.140		0.130	0.130				
O	0.240	0.260		0.251	0.249				
P	2.826	2.886		2.858	2.858				
Q	0.178	0.198		0.188	0.188				
R	0.140	0.165		0.151	0.150				
S	0.720	0.780		0.760	0.760				
T	1.220	1.280		1.250	1.250				
U	1.245	1.255		1.250	1.250				
V	5.990	6.010		6.000	6.000				
W	2.495	2.505		2.500	2.500				
X	0.490	0.510		0.500	0.500				
Y	0.020	0.040		0.033	0.033				
Z	0.313	0.318		0.313	0.313				
AA	0.760	0.765		0.760	0.760				
AB	0.215	0.220		0.219	0.219				
AC	0.316	0.321		0.316	0.316				
AD	1.745	1.755		1.750	1.750				
AE	0.990	1.010		1.000	1.000				
AF									
Accept/Reject									

Measured by: BA
Date: 19-01-09

Audited by: [Signature]
Date: 19/01/16

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	[Signature]
B	15.09.09	Dwg Rev updated	KJ	[Signature]